

Work Order ID 162254

Tuesday, May 30, 2017 1:57:52 PM

162254

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Item ID: D3943-051 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Handle Assembly
Start Date: 6/2/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 6/7/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan:  Date: MAY 30 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3943	E								

100 Weld per dwg A/R Steel rod Batch: 27925 0.00

100

Large Fab

Memo

2.20

Large Fab

Drill handle assembly and assemble as per dwg

(4) DYC
17/05/31

110 QC5- Inspect part completeness to step on W/O 0.00

110

QC

Memo

1.21

Quality Control

(4) 17-06-05

DAS
9
9-89

120 QC9- Inspect visual per QS1004- Fusion Welds 0.00

120

QC

Memo

0.00

Quality Control

(4) 17-06-05

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : ☐						
Misidentified ☐	☐	Past Due ☐							

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130 *130* Powdercoat Powder Coating	Hybrid safety Yellow 4.3.5.12 Memo: <i>M 116329.</i> 1- MASK THREADS PRIOR TO PAINTING AS PER DWG 2- POWDER COAT: Start Time: <i>1:00</i> Oven Temperature: <i>320°</i> Finish Time: <i>4:30</i>	0.00 0.61				<i>4</i>	<i>φ</i>	<i>1708-1</i>	<i>234</i> <i>9-89</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.04				<i>4</i>			DAS <i>9-89</i> AUG 02 2017
150 *150* Packaging Packaging	Identify as per dwg & Stock Location <i>WAOO1</i> Memo <i>on 002</i>	0.00 0.04				<i>4</i>			DAS <i>9-89</i> AUG 02 2017

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Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
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160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.40							
Quality Control									

AUG 02 2017

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

Picklist Print

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Parent Item: D3943-051

D3943-051

Parent Item Name: Handle Assembly

Start Date: 6/2/2017

Required Date: 6/7/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: add DEO DD 09.11.18 verified by:JLM IPP Rev:B as
per dwg REV.C DD 10.02.22 verified by:EC IPP REV:C 11.08.16 AS
PER REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3943-5		Manufactured	No			100	Each	5.0000	1	4			
D3943-5									**				
Plate												DYC 17/05/30	

Location	Loc Qty	Loc Code
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WA002	5	
109238	1	
155259	4	

D3943-7		Manufactured	No			100	Each	19.0000	2	8			
D3943-7									**				
Stud												DYC 17/05/30	

Location	Loc Qty	Loc Code
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WA002	19	
155344	19	

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